

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020367**Date Inspected:** 01-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

OBG Segment 10BW-10CW

Shielded Metal Arc Welding (SMAW) in the 3G position of Bottom Panel 'T' rib splice weld # SP157-001-030. The welder is identified as 041713. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2213-B-U2-FCM-1. See attached photograph Pic_001

OBG Segment 10BW-10CW

Flux Core Arc Welding (FCAW) in the 3G position of Cross beam side SP to SP splice weld # OBE10C-004. The welder is identified as 040759. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-223(3)T-1.

OBG Segment 9DW

Shielded Metal Arc Welding (SMAW) in the 1G position of Counterweight connection plate weld # OBW9K-009.

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The welder is identified as 045204. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

OBG Segment 10BW-10CW

Flux Core Arc Welding (FCAW) in the 1G position of Bottom Panel splice weld # OBE10C-003. The welder is identified as 053486. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-223(3)T-1.

OBG Segment 10AW-10BW

During in process visual inspection this QA Inspector observed ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) on Counterweight Side SP to SP splice weld.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
